

Date: Wednesday, 11/06/2006 10:04:32 AM
 User: Eric Charbonneau

Process Sheet

Customer : CC-DAR01 Drawing Name : SKIDTUBE EC135 PROTOTYPE
 Job Number : 022A
 Estimate Number : 10068
 P.O. Number : *N/A*
 This Issue : 7/19/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 5/9/2006 Type : R & D LANDING GEAR
 Previous Run : 020A
 Written By : _____
 Checked & Approved By : _____
 Comment : Project #: _____
 Description: _____

Part Number : INITIAL PROTOTYPE *D3510-041*
 Drawing Number : P601-637
 Project Number : P601-637
 Drawing Revision : *N/A*
 Material : *N/A*
 Due Date : 2/1/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MFG ENGINEERING MFG ENGINEERING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

Turn as per Dwg D3510
Mat'l M6061T6T3500W0375
Batch: 101448 Qty: 3
Inspect Level 2 BC 06.07.27
mill - mill as per Dwg Jul 06.08.11
QC2 - Inspect Jul 06.08.11
QC8 - Second Check E 06.08.26 (NOT A JOINT)
Welding - Weld as per ENJ - Fill Hole for repair BE 06-08-15
A/R AL. ROD Batch: M100660
GA - Transfer Drill Wear Plate Holes Jul 06.08.16
Fin. - Chemical Conversion as per Part ASI 005 4.1
QC3 - Inspect ECC. E 06.08.24
PTO

2.0 PG PURCHASING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

Pick:

Qty	Part #	Desc	Batch
2	NAS1330C4KB271	INSERT	M101325
6	NAS133C3KB316	INSERT	M17905
2	NAS1330C3KB216	INSERT	M17905

06.06.18

Finishing Install INSERTS AS PER DW D3510

QC5 Inspect Work To Current Step. 06.06.18

ST Identify Stock.

Place into
em's lab
06.06.18

Process Sheet

Customer: CC-DAR01

Drawing Name: SKIDTUBE EC135 PROTOTYPE

Job Number: 022A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

ea
06-08-15

4.0	ENGINEERING 1	ENGINEERING RESOURCE #1
-----	---------------	-------------------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
ENGINEERING RESOURCE #1
Approval of project manager _____

5.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
DOCUMENT CONTROL
Inspection Level 21

06-08-25

6.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
MFG ENGINEERING
Manufacture Prototype as per Dwg's Supplied By Engineering
Comments:

N/A
06-08-15

06-08-15

11-11-11

Process Sheet

Division of...

...

...

...

...

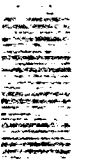
...



...

...

...



...

...

...



...

...

...



...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

...

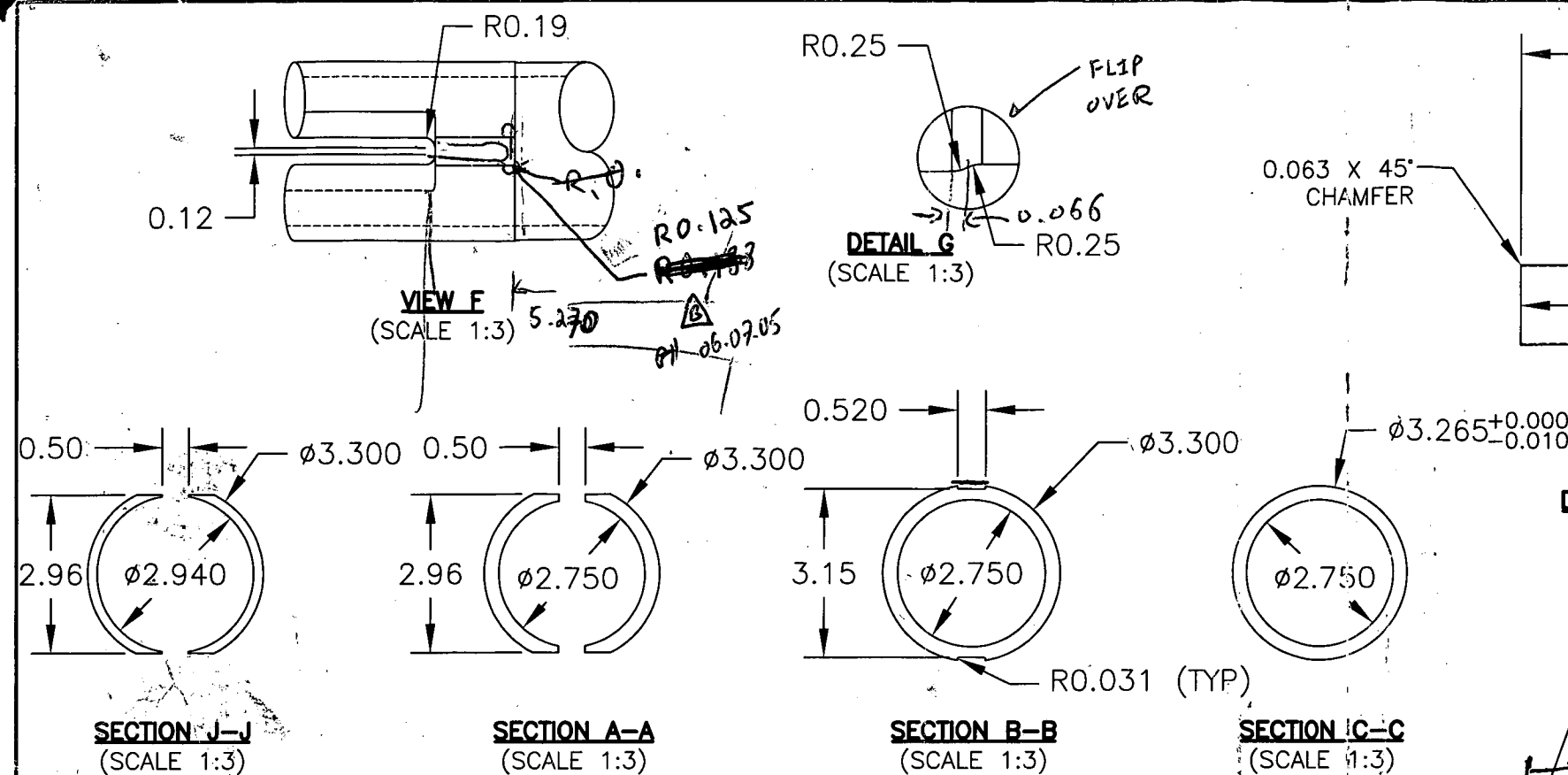
...

...

...

...

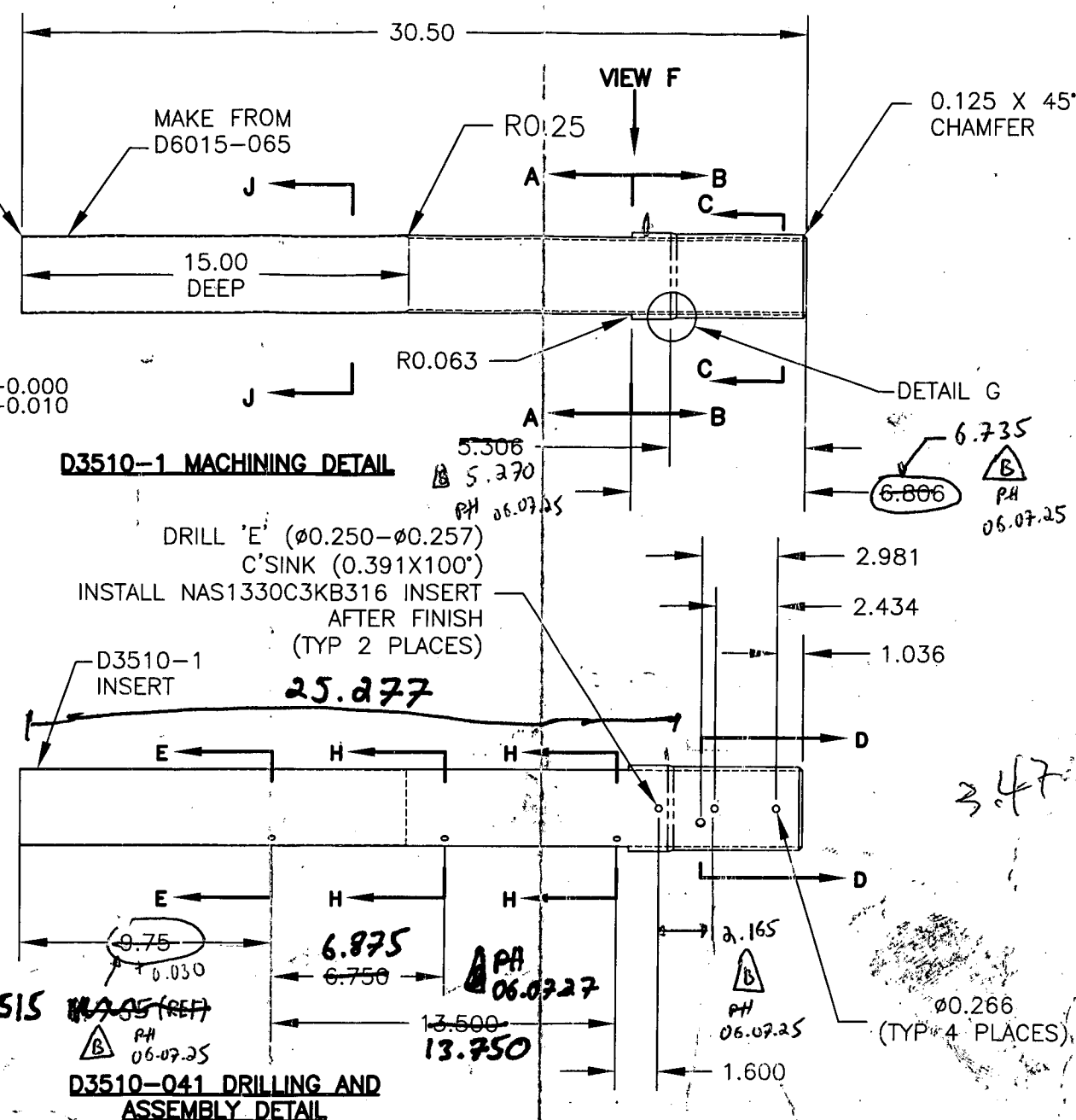
...



D3510-041 INSERT ASSEMBLY

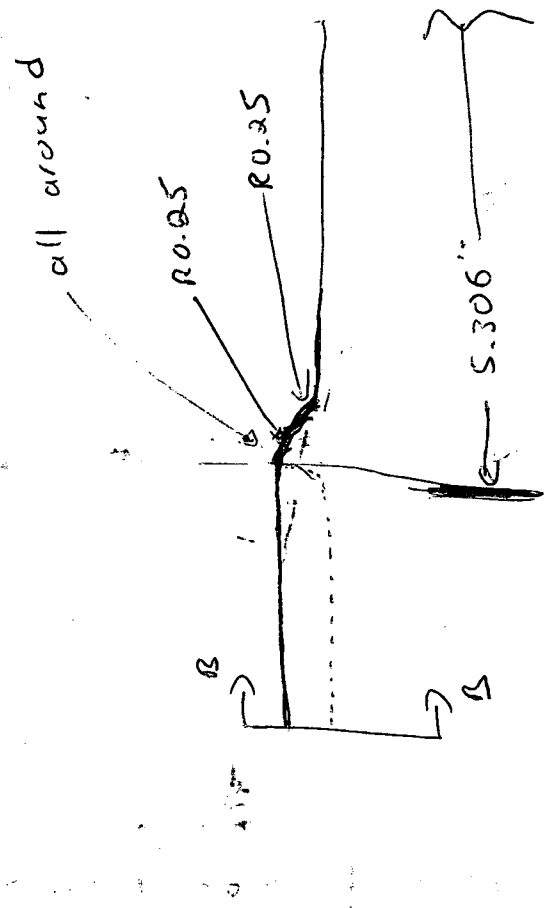
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.06.19 20

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

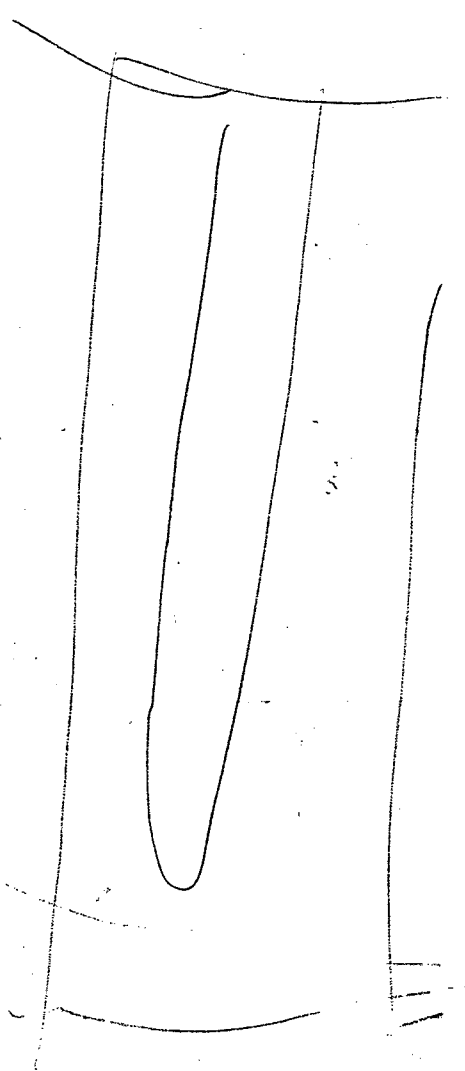
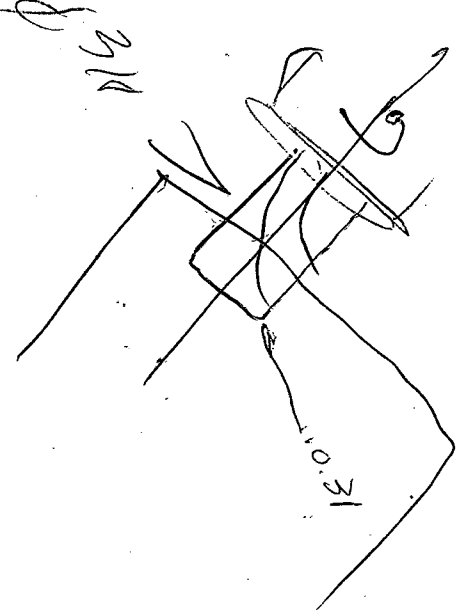


QTY - 041	PART NUMBER	DESCRIPTION
X	D3510-041	SKIDTUBE INSERT ASSEMBLY
1	D6015-065	EXTRUSION
2	NAS1330C3KB216	INSERT
6	NAS1330C3KB316	INSERT
2	NAS1330C4KB271	INSERT

A	06.04.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3510 REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE SKIDTUBE INSERT SCALE 1:8



DETAIL C



2

556.25

258.2

100.00

1029.21

212.9

DART AEROSPACE LTD		Work Order:
Description: <i>Shuttle insert</i>		Part Number: <i>D3510-1</i>
Inspection Dwg: <i>D3510</i> , Rev: <i>A</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST *Page 1 of 2*

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	±.03					
2.300	±.010					
2.940	"	2.940	✓			
2.96	±.03					
.50	"					
.520	±.010					
3.231	±.010					
3.265	±.000 -.010	3.263	✓			
3.19	±.03					
.12	"					
3.25	"	3.25	✓			
.066	±.010	.066	✓			
.063 x 45°	±.010	.063	✓			
30.50	±.03	30.50	✓			
15.00	"	15.00	✓			
3.25	"					
3.063	±.010		✓			
.125 x 45°	"	.125	✓			
5.270	"	5.270	✓			
6.735	"					
25.277	"	25.277	✓			
2.981	"					
2.474	"					

Measured by: <i>BG1</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: <i>06.08.27</i>	Date: <i>06.08.26</i>	Date: <i>06.08.26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

05/02/2006 From: MARMON/KEYSTONE
M/K OR:
C.P.O. BN9722
C PART:

INIT.

To:

OR. REF:
SLSPRS:

M101448

KAISER ALUMINUM
ENGINEERED PRODUCTS
9700 SOUTH HARLEM AVE
BRIDGEVIEW IL 60455

KAISER ALUMINUM
MATERIAL CERTIFICATION
MARMON-KEYSTONE CORP
10700 MARMON DR
BOLINGBROOK, IL 60440-3060

PAGE 1

MARMON-KEYSTONE CORP

BOLINGBROOK IL 60440 60-23640

04/12/06

SOLD TO

PURCHASE ORDER

DATE PRINTED

3.500 +/- .015 IND +/- .015 MEAN O.D.

HB3.500X0.375X24FT

X .375 WALL SMLS HOLOBAR

CUSTOMER PART NUMBER DESCRIPTION

983171-003

101148094

6061-T6511

RELEASE-ITEM

LOT

ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEND
KTR044478	0001 01	47.6	42.5	18.4		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	Ea Tot
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA	0.05 0.15

APPLICABLE REQUIREMENTS:

ASTM-B241-02-STENCILED
ASTM-B221-02
ASME-SB241 1998 SECT II
AMS-QQ-A-200/8 TYPE 1
ASTM-B345-02
UNS#96061

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Q. C. REVIEWED

Frank E. Watson
Quality Assurance Manager

AT 3.5.375 733